

Work Order ID 65627

January 20, 2011 11:49:04 AM



Page 1

Item ID: D3909-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Fwd Crosstube

Start Date: 1/20/11 Start Qty: 30.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3909

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3909

Prog Rev: C

Dwg Rev: C

Deburr as required

B11-1-21

31

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65627

January 20, 2011 11:49:04 AM



Page 2

Item ID: D3909-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Fwd Crosstube

Start Date: 1/20/11 Start Qty: 30.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Sublet

can't
(430)

P10 →



QC

Memo

Quality Control

150

Identify as per dwg & Stock Location: *90*

0.00



Packaging

Memo

Packaging

0.00

1.1.64 SP 130x

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

Q2 11/01/20
ME

11-01-24

W/O: 65607		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/24	# 120	took Qty x1 For QC inspection template	S	11/21/24	x1		S 11/21/24

Part No: D3909-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 20, 2011 11:49:03 AM

Page 1

Work Order ID: 65627

Parent Item: D3909-1

Parent Item Name: Lug Plate, Fwd Crosstube



Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC
per revPA3 DD verified by:EC
DD 10.04.20 verified by:EC
IPP RevB: as
IPP RevC: as per dwg revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

88.6003

0.195

6.157895

6.5



1811-1-21

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT

88.6003

114799

0.5003

116437

24.1

116623

64

116437

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

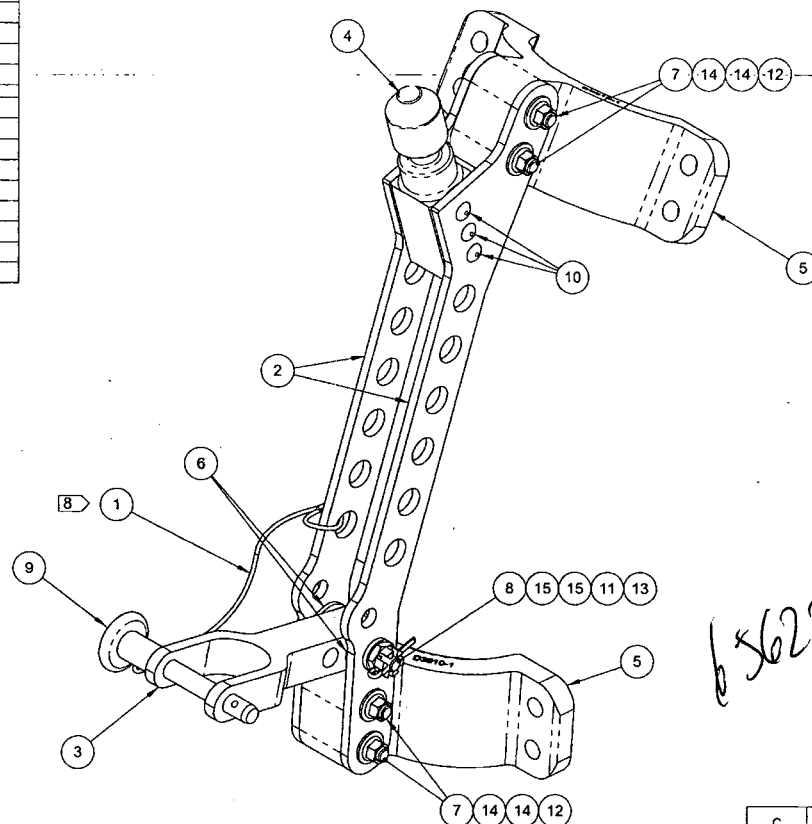
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLES FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

65627

RELEASED
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5); 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041/-5).	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED. ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED. SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3909 REV. C SHEET 1 OF 5 TITLE FWD X-TUBE LUG ASSY SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH	DATE 10.06.18	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3910-1
X-TUBE LUG
2 PL

D2690-6
LANYARD

MS17984-C413
PIP PIN

D3917-1
WASHER

D3909-5
EYEBOLT STUD

MS20615-4M20
RIVET
3 PL

D3909-1
FWD X-TUBE LUG PLATE
2 PL

D3909-3
FWD LOWER ATTACH ARM

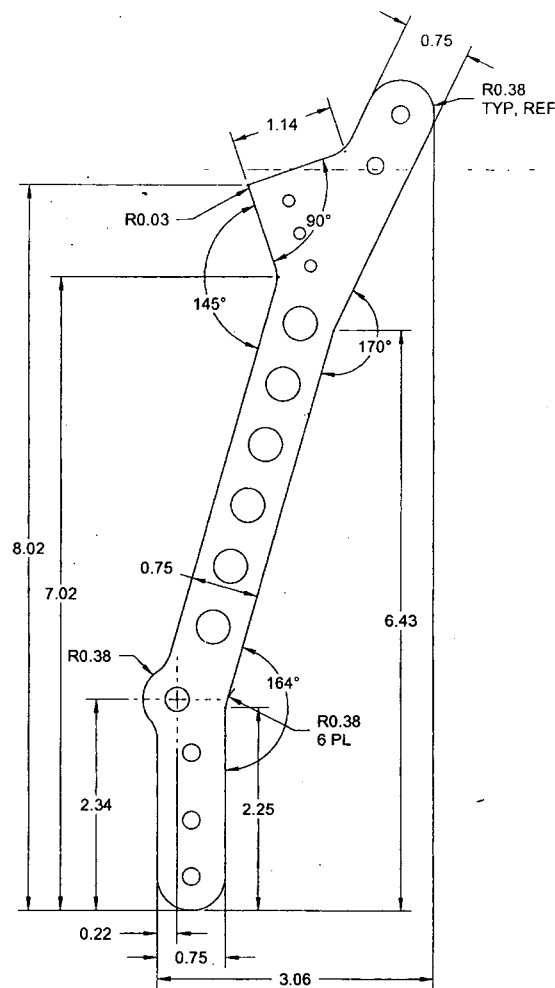
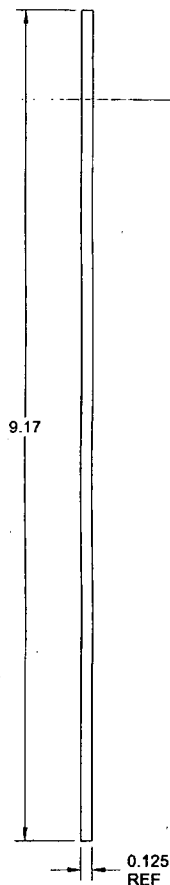
AN3C12A BOLT
NAS1149C0332R WASHER, 2X
MS21043-3 NUT
4 PL

AN3C13 BOLT
NAS1149C0363R WASHER, 2X
AN310C3 NUT - CASTELLATED
MS24665-151 COTTER PIN

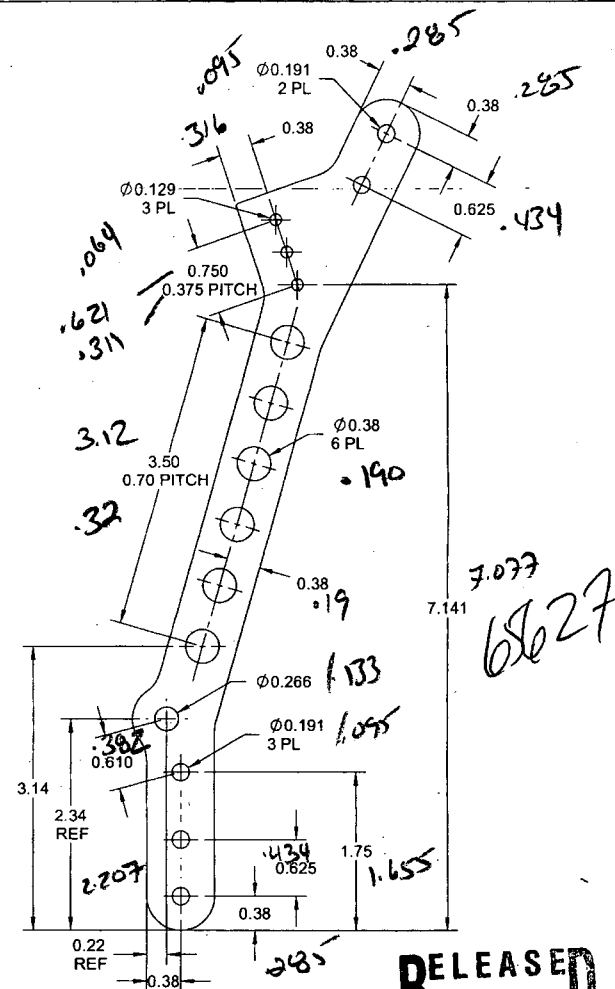
D3909-041 FWD X-TUBE LUG ASSY

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2010-08-04

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APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
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D3909-1 FWD X-TUBE LUG PLATE



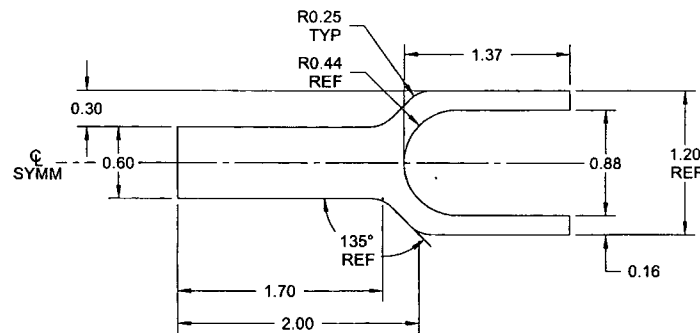
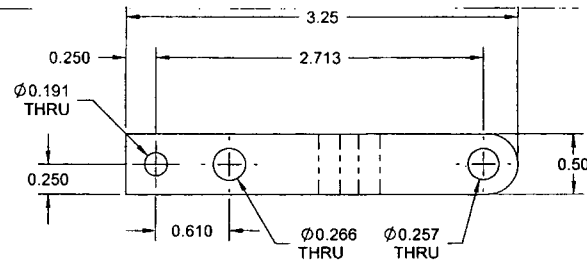
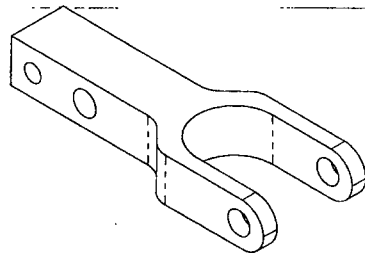
(SUPPLEMENTAL VIEW)

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

RELEASED
2010-08-01

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MFG. APPR.		D3909	SHEET 3 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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D3909-3 FWD LOWER ATTACH ARM

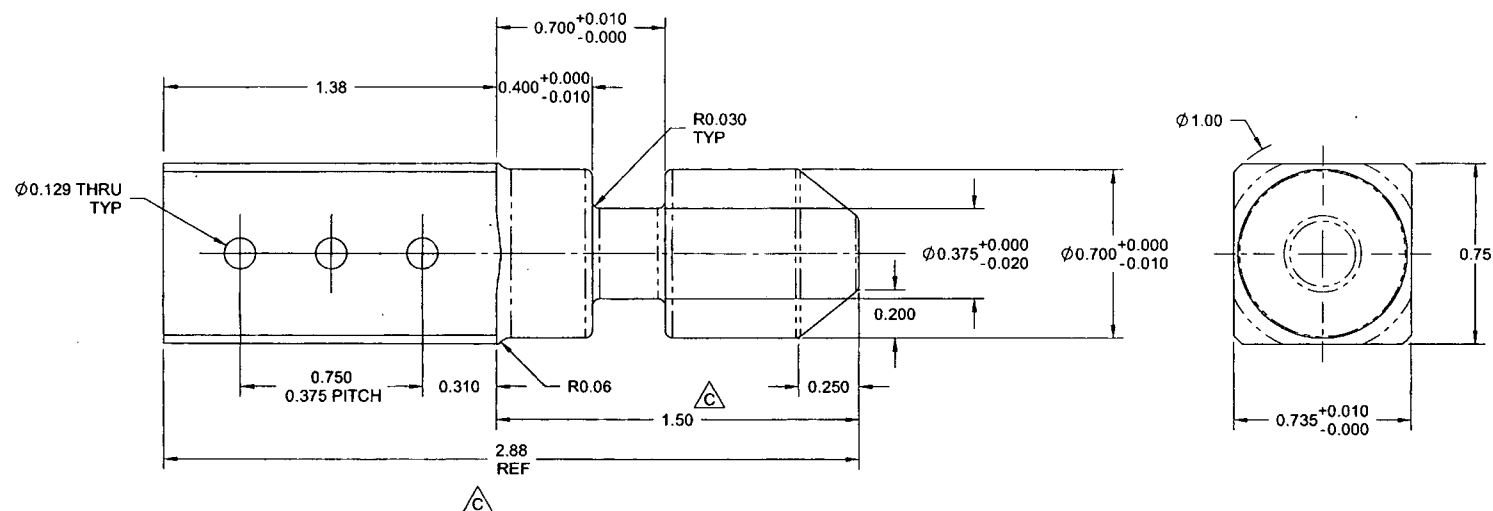
65627

RELEASED
2010-08-06

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3909	REV. C
MFG. APPR.		SHEET 4 OF 5	
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D3909-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LOG ASSY	NTS
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2010-08-04
JPH

65627

